

Work Order ID 67840

Thursday, March 31, 2011 3:47:03 PM



Page 1

Item ID: D350-689-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Dual High Back Seat Ass'y

Start Date: 4/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

N

Date: 11-03-31

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9498

A

IIN D350-689

A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Assemble as per IIN 350-689-041

9511/04/25 @

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*8/16/12**(+)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67840

Thursday, March 31, 2011 3:47:03 PM



Page 2

Item ID: D350-689-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Dual High Back Seat Ass'y

Start Date: 4/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M115128.

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00
300°
9:30

1 BR 11-4-25

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

ES 4/04/25 (V)

140

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

Assemble as per Dwg IIN-D350-689

ES 4/24/25 (V)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67840

Thursday, March 31, 2011 3:47:03 PM



Page 3

Item ID: D350-689-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Dual High Back Seat Ass'y

Start Date: 4/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

8 11/04/25

JP 67839

11/4/25

11/4/25

MF 11-04-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, March 31, 2011 3:47:09 PM

Page 1

Work Order ID: 67840

Parent Item: D350-689-041

Parent Item Name: Dual High Back Seat Ass'y









Start Date: 4/1/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H Removed Sub-Parts 06-02-09 JLM
 IPP Rev:I As per NCR 070 06-09-06 JLM IPP Rev:J as per
 DSI 9498 DD 10.02.12 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3016-041  Seat Frame Assembly		Manufactured	No			110	Each	0.0000	1	1			
				67842-X1						EL	11-4-21		
D3017-041  Back Frame Assembly		Manufactured	No			110	Each	0.0000	1	1			
				67841-X1						EL	11-4-21		
D3023-1  Back Panel		Manufactured	No			110	Each	0.0000	1	1			
				67844-X1						EL	11-4-21		
MS20600-AD4W2  Rivet		Purchased	No			110	Each	268.0000	40	40			
										EP	5/04/25		

Location

Loc Qty

Loc Code

ST321

268

114348

8

116391

100

116471

60

116805

100

AN3-12A

Purchased

No

140

Each

121.0000

3

3



Bolt

Location

Loc Qty

Loc Code

ST351

121

114536

21

116786

100

1117317

40x

EP 5/04/25

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, March 31, 2011 3:47:09 PM

Work Order ID: 67840

Parent Item: D350-689-041

Parent Item Name: Dual High Back Seat Ass'y

Start Date: 4/1/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L

NAS1149D0332J

Purchased

No

140

Each

0.0000

17

17



4D M117291 (17x)

Washer

D3021-041

Manufactured

No

140

Each

0.0000

1

1



67845 x 1

Tube Assembly

D3022-1

Manufactured

No

140

Each

5.0000

1

1



Seat Pan

Location

Loc Qty

Loc Code

WA025

5

52352

5

D3024-1

Manufactured

No

140

Each

8.0000

3

3



Spacer

Location

Loc Qty

Loc Code

ST030

8

43394

2

50343

6

D3028-1

Manufactured

No

140

Each

6.0000

4

4



Stud

Location

Loc Qty

Loc Code

ST031

6

42446

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, March 31, 2011 3:47:09 PM

Work Order ID: 67840

Parent Item: D350-689-041

Parent Item Name: Dual High Back Seat Ass'y

Start Date: 4/1/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

D3029-1 Manufactured No

140 Each

4.0000

2

2



Spring



Handwritten signature
4/1/25

Location

Loc Qty

Loc Code

ST034

4

46848

4

D3030-1

Manufactured No

140 Each

4.0000

2

2



Lock



Handwritten signature
4/1/25

Location

Loc Qty

Loc Code

ST031

4

50363

4

D3031-1

Manufactured No

140 Each

5.0000

2

2



Loop



Handwritten signature
4/1/25

Location

Loc Qty

Loc Code

ST031

5

43395

5

MS20600-AD4W3

Purchased No

140 Each

969.0000

6

6



Cherry Rivets



Handwritten signature
4/1/25

Location

Loc Qty

Loc Code

ST321

532

111636

532

WA018

437

107939

437

Handwritten signature
6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, March 31, 2011 3:47:10 PM

Page 4

Work Order ID: 67840

Parent Item: D350-689-041

Parent Item Name: Dual High Back Seat Ass'y

Start Date: 4/1/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

140

Each

2,134.000

17

17



Nut

Location

Loc Qty

Loc Code

ST300

2134

116391

534

116540

800

116549

800



EBa/04/25

17

MS21042L4

Purchased

No

140

Each

3,239.000

6

6



Nut

Location

Loc Qty

Loc Code

ST300

3239

116188

1239

116823

2000



EBa/04/25

6

MS24693-S272

Purchased

No

140

Each

137.0000

4

4



Screw

Location

Loc Qty

Loc Code

ST288

137

116391

37

116737

100



EBa/04/25

2

MS27039-1-17

Purchased

No

140

Each

54.0000

4

4



Screw

Location

Loc Qty

Loc Code

ST292

54

11540

54



EBa/04/25

4

Thursday, March 31, 2011 3:47:10 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, March 31, 2011 3:47:10 PM

Page 5

Work Order ID: 67840

Parent Item: D350-689-041

Parent Item Name: Dual High Back Seat Ass'y

Start Date: 4/1/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-19 Purchased No
Screw

140 Each 114.0000

6

Location

Loc Qty

Loc Code

ST292

114

100089

14

112794

100

MS27039-4-21 Purchased No
Screw

140 Each 52.0000

6

Location

Loc Qty

Loc Code

ST293

52

114055

2

116845

50

NAS1149D0432J Purchased No
WASHER

140 Each 262.0000

6

Location

Loc Qty

Loc Code

ST298

262

114718

62

116583

200

Thursday, March 31, 2011 3:47:10 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D076-612 REV. A AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D076-612 REV. 0

REF TCCA STC: SH94-38

REF FAA STC: SR00298NY

REF EASA STC: EASA.IM.R.S.01086

PURPOSE:

TO PROVIDE AN ALTERNATE INSTALLATION CONFIGURATION THAT PROVIDES BETTER MIRROR POSITION TO SEE LONG LINES AND PREVENTS INTERFERENCE BETWEEN THE L-BRACKETS AND THE DOOR FRAME IN THE FWD CORNER OF THE WINDOW. ADDITIONALLY, OPTIONS ARE GIVEN TO PROVIDE MORE FLEXIBILITY IN ALIGNING THE L-BRACKETS WITH THE EXISTING WINDOW FRAME HOLES.

CHANGE:

IT IS ACCEPTABLE TO INSTALL THE D076-612-011/-015 CARGO MIRROR IN THE CONFIGURATION SHOWN IN FIGURES 1 AND 3 OF THIS SERVICE INSTRUCTION. TO INSTALL PER THIS CONFIGURATION, THE CARGO MIRROR SHOULD BE INSTALLED PER IIN-D076-612 ("IIN") AND MAINTAINED PER ICA-D076-612 ("ICA"), HOWEVER:

- 1) IIN - FIGURE 1 AND ICA - FIGURE 25-1 IS AMENDED PER FIGURE 1 OF THIS SERVICE INSTRUCTION.
- 2) IIN - FIGURE 3 AND ICA - FIGURE 25-3 IS AMENDED PER FIGURE 3 OF THIS SERVICE INSTRUCTION.

WHEN INSTALLING THE D2271 L-BRACKETS, THE FOLLOWING MODIFICATIONS ARE ACCEPTABLE. REFER TO FIGURE 2 OF THIS SERVICE INSTRUCTION FOR REFERENCE.

- 1) IT IS ACCEPTABLE TO SHIM THE D2271 L-BRACKETS AS REQUIRED. THE SHIMS MUST BE ALUMINUM.
- 2) IT IS ACCEPTABLE TO USE LONGER NAS1738B-4-X BLIND RIVETS AS REQUIRED (FOR EXAMPLE TO ACCOMMODATE SHIMS).

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67840

P/1103-31

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01
APPROVED BY: <i>[Signature]</i> D. SHEPHERD (DE # 02)
DATE: <u>09.10.30</u>
CERT. NO.: <u>SH94-38</u>
ISSUE NO.: <u>2</u>

A	NEW ISSUE	CP	09.10.30
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>qp</i>	DART AEROSPACE LTD	
DRAWN	<i>qp</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9489	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CARGO MIRROR INSTALL MOD.	NTS
DATE	09.10.30	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9489	SHEET 2 OF 3
APPROVED	92	TITLE	SCALE
DE APPR.	92	CARGO MIRROR INSTALL MOD.	NTS
DATE	09.10.30	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

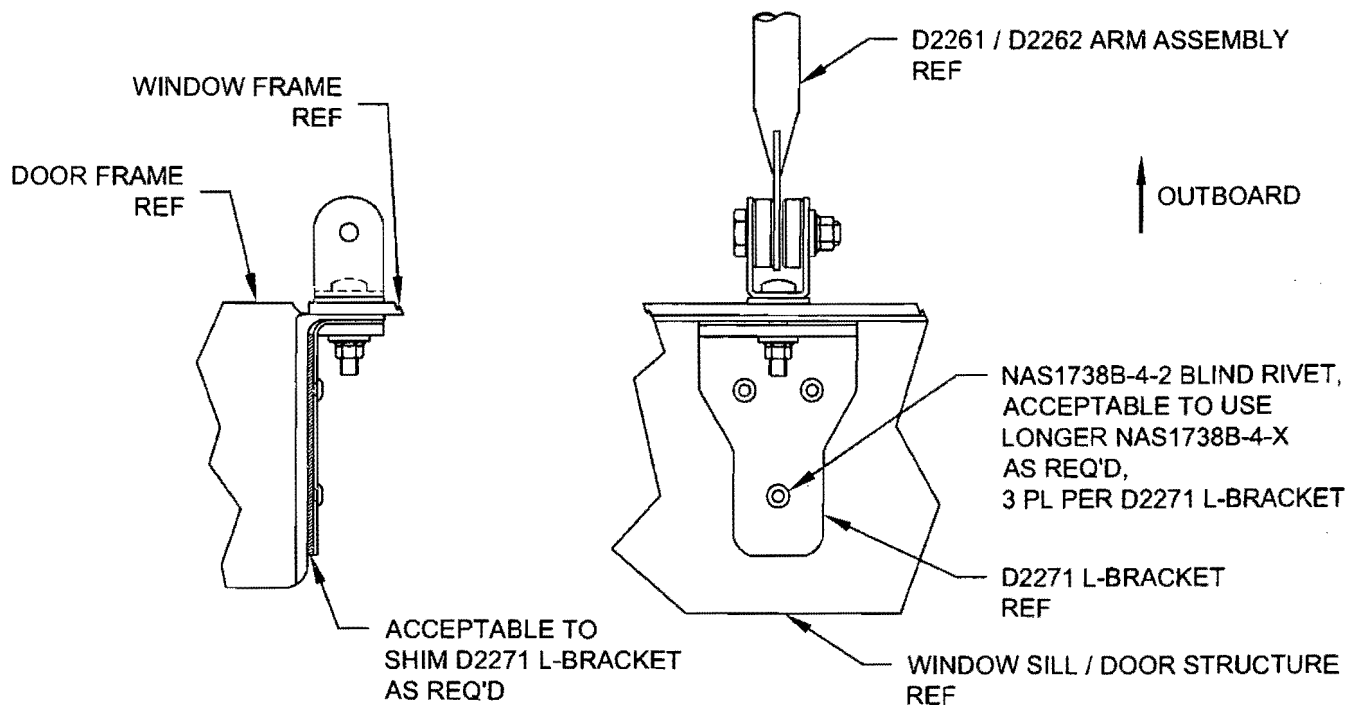


FIGURE 2: L-BRACKET INSTALL MOD.

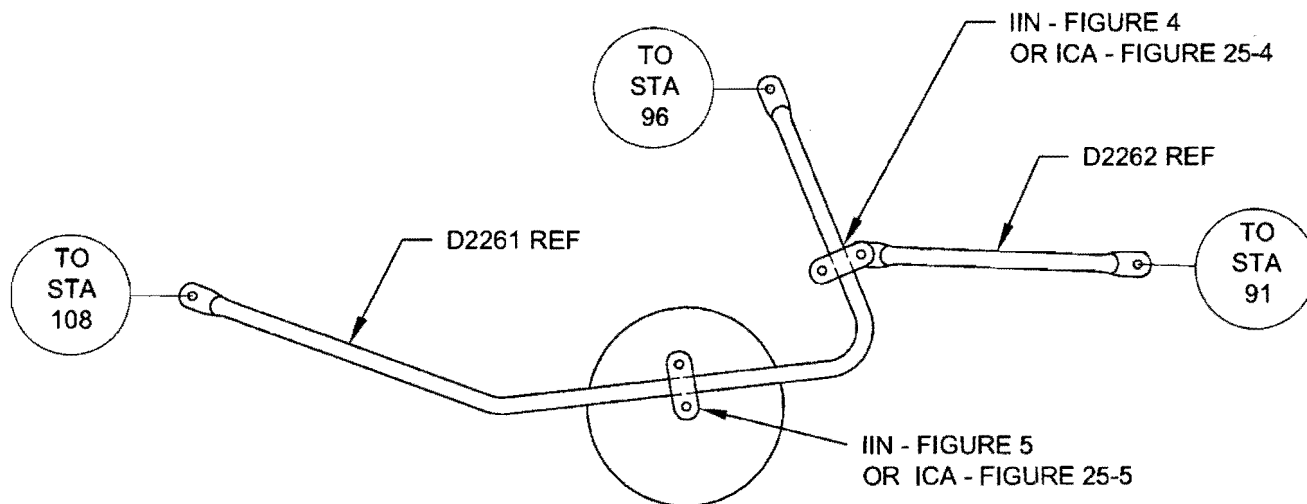


FIGURE 3: ALTERNATE CONFIGURATION

W/0 67840

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	09.10.30
CERT. NO.:	SH94-38
ISSUE NO.:	2

DESIGN	<i>q</i>	DART AEROSPACE LTD	
DRAWN	<i>q</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9489	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CARGO MIRROR INSTALL MOD.	NTS
DATE	09.10.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

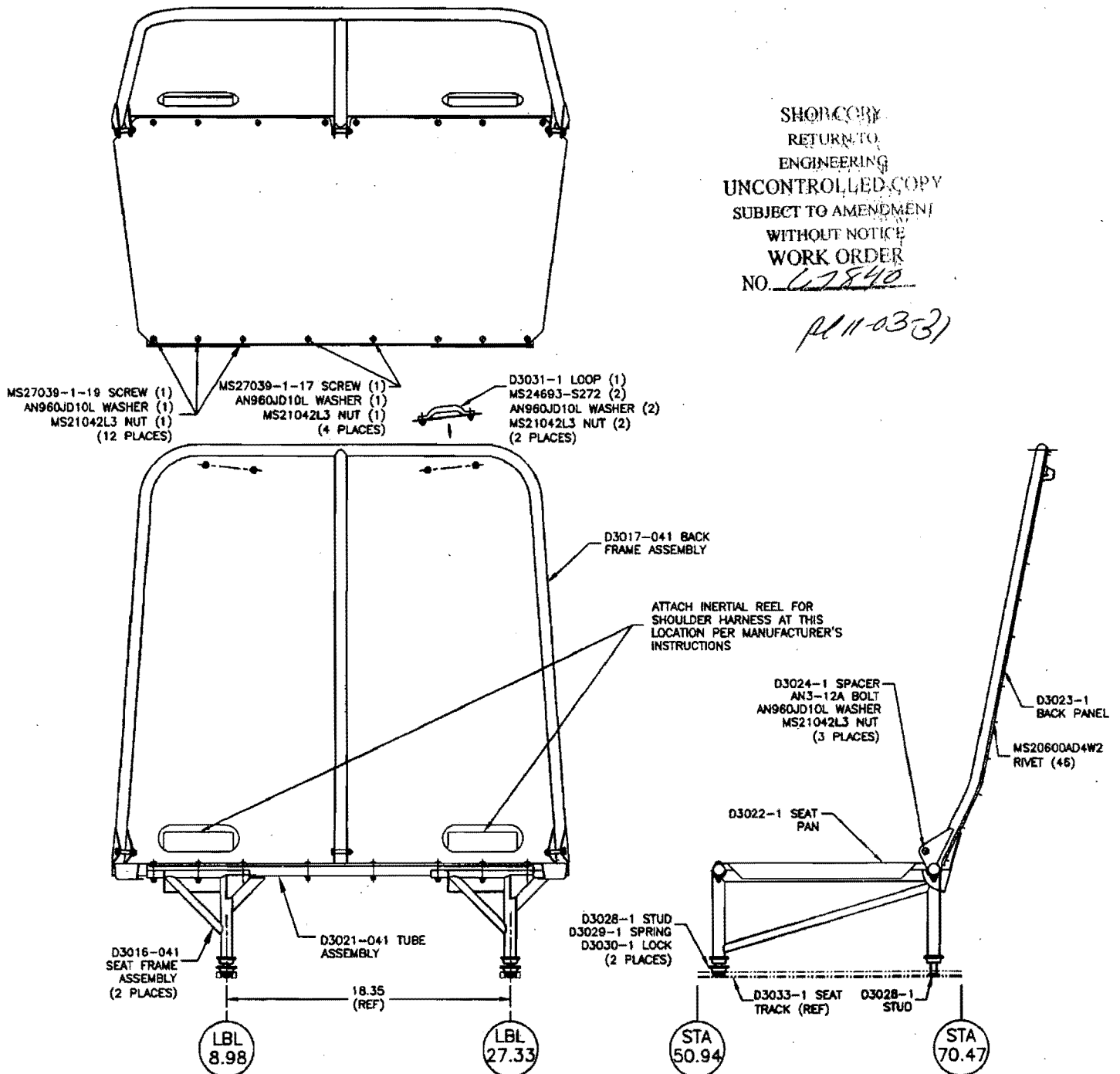


FIGURE 6: Installation of D350-689-041 Dual High Back Seat Assembly

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Revision: A
Date: 01.05.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O 67840

1. INTRODUCTION

The Dart D350-689-011 Dual High Back Seat Installation seats two passengers and can be installed in the forward left hand position normally occupied by the copilot on the AS 350/355 series rotorcraft. The D350-689-013 Floor Provisions Kit allows the operator to prepare several aircraft for the installation of the D350-689-041 Dual High Back Seat Assembly and move the seat from aircraft to aircraft.

The components in the Dart Dual High Back Seat Installation are as defined in the table in section 5 of this document. For convenience, only the last three digits of the Part No. are listed on the top row of each table. The quantity of each component which is included in the D350-689-011 Dual High Back Installation is as defined in the column labeled -011.

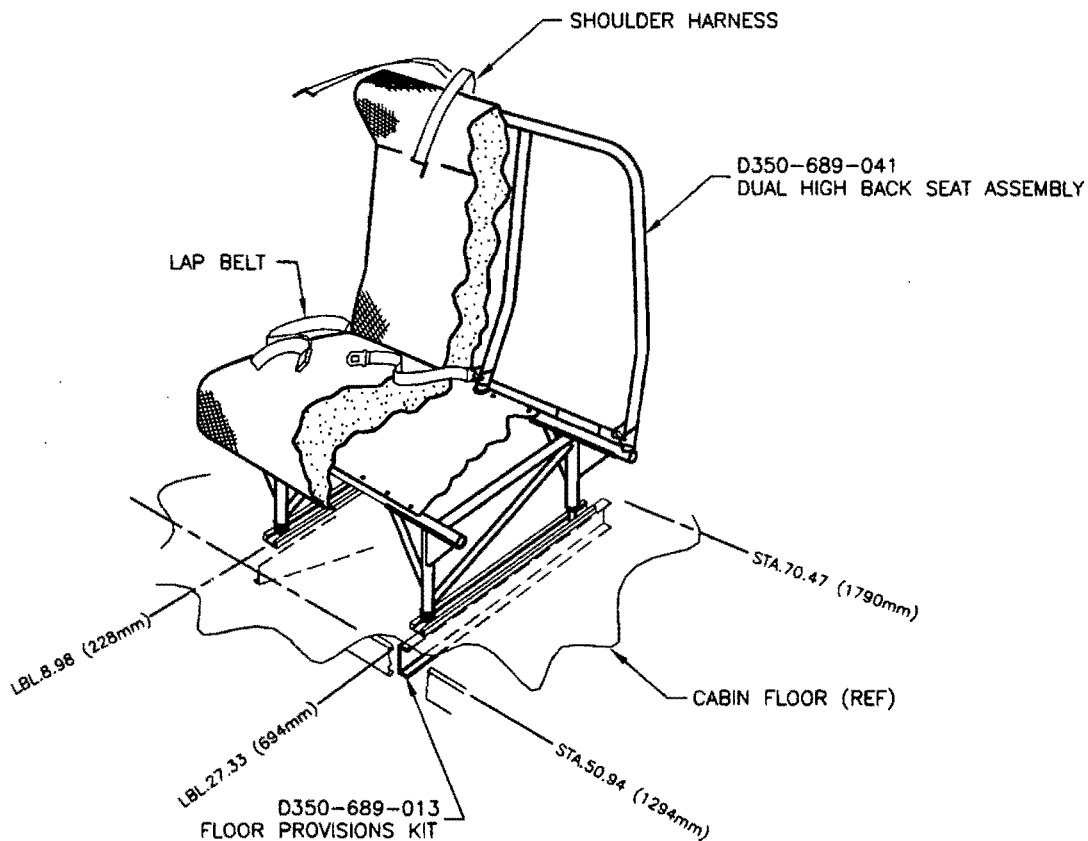


Figure 1: D350-689-011 Dual High Back Seat Installation

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Revision: **A**
Date: 01.05.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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